

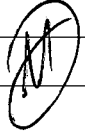
Work Order ID 163077

Wednesday, June 21, 2017 11:16:07 AM

163077

Page 1

Item ID: D5331-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly, RH
 Start Date: 7/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/19/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan:  Date: JUN 21 2017 Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5331	B

100 Weld per dwg A/R S.S. rod Batch: M/35067 0.00
 Large Fab

100
 Large Fab
 Large Fab

Memo

2.77

- 1- Assemble ribs and weld as per dwg D5331 using DT10197
 inspect before welding mesh
 54.63 CRITICAL DIMENSION
- 2- Weld gusset and handle plate as per dwg
- 3- Cut mesh as per dwg D5328-1
- 4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary
 and trim to clear fasteners holes on the ends
- 5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331
 Take lid to locate hinge and bracket
 On one of the hinge weld stopper D4016-7 as per dwg
- 6- Weld D5325-5 foot as per dwg (CRITICAL)

/x DAS **43** JUL 21 2017
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>								Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																											

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Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Required Date: 7/19/2017 **Req'd Qty:** 1.00

Reference: SCHEDULED/C

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NB2*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

110

QC

Memo

0.00

Quality Control

DAS
9
9-89

0.00

120

QC

Memo

0.02

Quality Control

DAS
9
9-89

0.00

125

HandFinish

Memo

0.35

Hand Finishing

MS 34 9.80

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>n 138014</i> Memo 1- Plug holes and mask only interior of hinge (6) prior to powder coat 1ST COAT: START TIME: <i>5:05</i> OVEN TEMPERATURE: <i>375°</i> FINISH TIME: <i>5:20</i> *****2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.55				<i>1</i>	<i>0</i>	<i>17-07-25</i>	<i>138014</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>1x</i>	<i>0</i>	<i>17-07-26</i>	<i>DAS 15 9-89</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 163077

Wednesday, June 21, 2017 11:16:07 AM

163077

Page 4

Item ID: D5331-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Required Date: 7/19/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
170									
Packaging	Memo	0.01							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

D5337-012/B163075

12 9 98 1462125

17/7/26 98



JUL 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER : ☐																							

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Page 1

Work Order ID: 163077

163077

Parent Item: D5331-042

D5331-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/10/2017**Required Date:** 7/19/2017**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM
IPP REV:B 17.03.27 ADD D4016-7 DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓*D4016-7* Stop		Manufactured	No			100	Each	7.0000	1	1		DAS 43 9-89	JUL 03 2017
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				7					
				158867				7					
✓*D2581* Mounting Bracket		Manufactured	No			100	Each	38.0000	2	2		DAS 43 9-89	JUL 03 2017
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				38					
				161800				38					
✓*D3913-15* Wide Handle Plate		Manufactured	No			100	Each	37.0000	1	1		DAS 43 9-89	JUL 03 2017
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				37					
				161938				37					
✓*D4016-1* Hinge Half, Base		Manufactured	No			100	Each	94.0000	6	6		DAS 43 9-89	JUL 03 2017
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				94					
				158630				3					
				159537				91					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
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								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐						
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐						
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Misidentified ☐	Past Due ☐										

Picklist Print

Wednesday, June 21, 2017 11:16:06 AM

Work Order ID: 163077

163077

Parent Item: D5331-042

D5331-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/10/2017

Required Date: 7/19/2017

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No

100 Each 54.0000 1 1

DAS

43

9-89

JUL 03 2017

✓ *D4021-1*

Handle Plate

** B161473 → 1x

Location

Loc Qty

Loc Code

WA004

54

161473

24

161900

30

M304EX0.75-16F

Purchased No

100 sf 716.9000 32 33.68421

DAS

43

9-89

JUL 21 2017

✓ *M304EX0 75-16F*

Expanded Metal Flat SS

** 4137765 → 33x6

Location

Loc Qty

Loc Code

WA004

716.9

M136991

13.9

M137294

223

M137765

480

D5328-3

Manufactured No

100 Each 1.0000 1 1

DAS

24

9-89

JUL 17 2017

✓ *D5328-3*

Mesh Base, Aft

** B163109 → 1x

Location

Loc Qty

Loc Code

WA006

1

159015

1

D5328-5

Manufactured No

100 Each 2.0000 1 1

DAS

24

9-89

JUL 17 2017

✓ *D5328-5*

Mesh Base, Fwd

** B163113 → 1x

Location

Loc Qty

Loc Code

WA006

2

159377

2

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								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
OTHER : _____																									

Picklist Print

Page 3

Wednesday, June 21, 2017 11:16:06 AM

Work Order ID: 163077

163077

Parent Item: D5331-042

D5331-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/10/2017

Required Date: 7/19/2017

Start Qty: 1.00

Required Qty: 1.00

D5330-1 Manufactured No

100 Each 8.0000

2 2

✓ *D5330-1*

Handle Plate

**B161957 → 2x DAS 43 JUL 03 2017 9-89

Location

Loc Qty

Loc Code

WA004

8

161957

8

D3916-5 Manufactured No

100 Each 5.0000

2 2

DAS

43 JUL 17 2017 9-89

✓ *D3916-5*

Light Rib

**B163918 → 1x
B163114 → 1x

Location

Loc Qty

Loc Code

WA004

5

161958

1

161959

4

D5325-041 Manufactured No

100 Each 1.0000

1 1

DAS

43 JUL 03 2017 9-89

✓ *D5325-041*

Rib Assembly

**B163116 → 1x

Location

Loc Qty

Loc Code

WA004

1

159823

1

D5325-5 Manufactured No

100 Each 4.0000

4 4

DAS

43 JUL 17 2017 9-89

✓ *D5325-5*

Foot

**B163107 → 4x

Location

Loc Qty

Loc Code

WA004

4

158879

4

D5325-4 Manufactured No

100 Each 0.0000

1 1

DAS

43 JUL 03 2017 9-89

✓ *D5325-4*

Light Rib

**B163100 → 1x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____							

Picklist Print

Page 4

Wednesday, June 21, 2017 11:16:06 AM

Work Order ID: 163077

163077

Parent Item: D5331-042

D5331-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/10/2017

Required Date: 7/19/2017

Start Qty: 1.00

Required Qty: 1.00

✓ *D5326-041*	D5326-041	Manufactured	No	100	Each	0.0000	1	1	DAS	43	JUL 03 2017
	Rib Assembly								9-89		
✓ *D5326-043*	D5326-043	Manufactured	No	100	Each	0.0000	1	1	DAS	43	JUL 03 2017
	Rib Assembly								9-89		
✓ *D5327-1*	D5327-1	Manufactured	No	100	Each	9.0000	1	1	DAS	43	JUL 03 2017
	Rib								9-89		

Location

Loc Qty

Loc Code

WA004

9

158897

9

✓ *D5327-4*	D5327-4	Manufactured	No	100	Each	0.0000	1	1	DAS	43	JUL 03 2017
	Rib								9-89		
✓ *D5327-6*	D5327-6	Manufactured	No	100	Each	0.0000	1	1	DAS	43	JUL 03 2017
	Rib								9-89		
✓ *D5327-8*	D5327-8	Manufactured	No	100	Each	0.0000	1	1	DAS	43	JUL 03 2017
	Rib								9-89		
✓ *D5327-9*	D5327-9	Manufactured	No	100	Each	2.0000	2	2	DAS	43	JUL 03 2017
	Rib								9-89		

Location

Loc Qty

Loc Code

WA004

2

159831

2

✓ *D5327-11*	D5327-11	Manufactured	No	100	Each	0.0000	4	4	DAS	43	JUL 03 2017
	Rib								9-89		

Wednesday, June 21, 2017 11:16:06 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER : ☐																																																																							

Picklist Print

Wednesday, June 21, 2017 11:16:06 AM

Work Order ID: 163077

163077

Parent Item: D5331-042

D5331-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 7/10/2017

Required Date: 7/19/2017

Start Qty: 1.00

Required Qty: 1.00

D5327-13 Manufactured No

100 Each 1.0000

✓ *D5327-13*
Rib

** ~~B163093~~ → ~~V~~ DAS 43 JUL 03 2017
9-89

Location	Loc Qty	Loc Code
WA004	1	
159832	1	

D5327-15 Manufactured No

100 Each 18.0000

✓ *D5327-15*
Cap

** ~~B161209~~ → ~~V~~ DAS 43 JUL 03 2017
9-89

Location	Loc Qty	Loc Code
WA004	18	
161209	18	

D5329-1 Manufactured No

100 Each 12.0000

✓ *D5329-1*
Gusset

** ~~B162099~~ → ~~2~~ DAS 43 JUL 03 2017
9-89

Location	Loc Qty	Loc Code
WA004	12	
162099	12	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

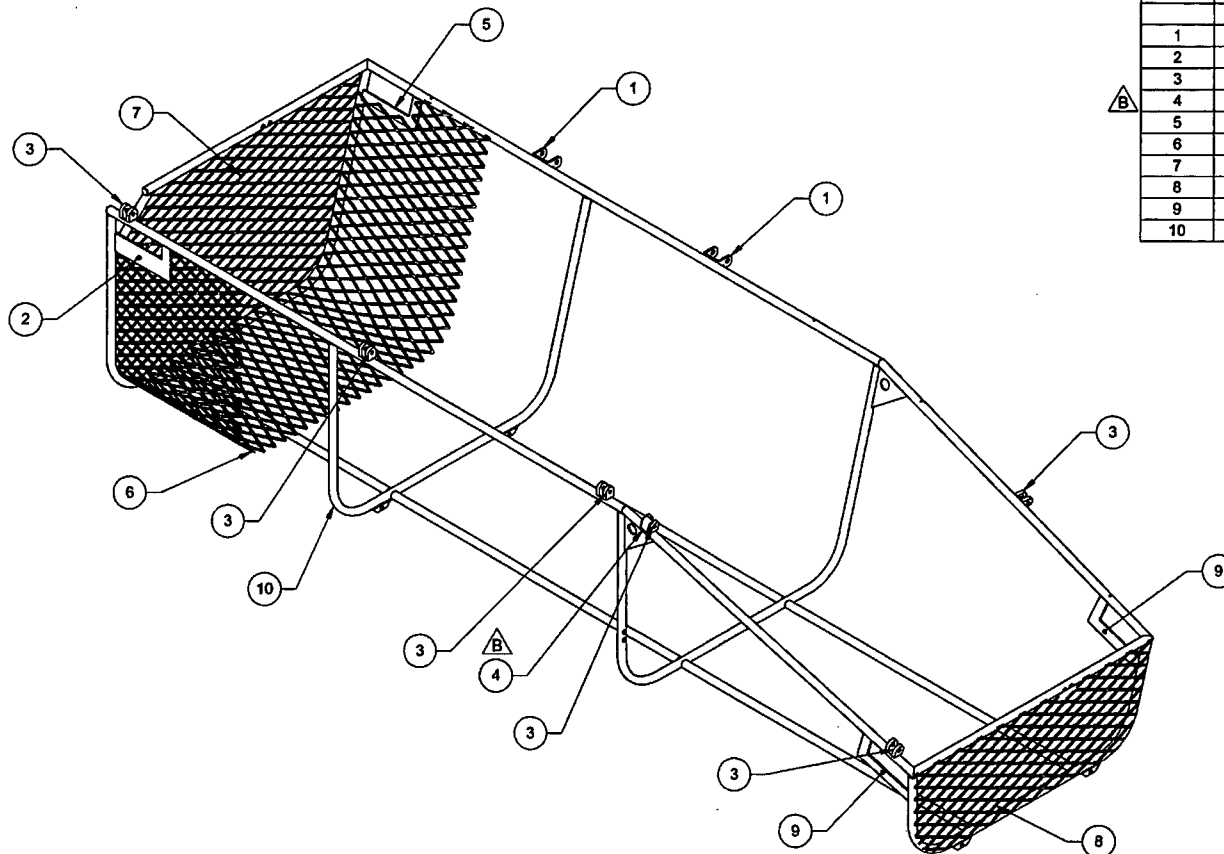
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

8 7 6 5 4 3 2 1

ITEM	QTY. -041	P/N	DESCRIPTION
	X	D5331-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	6	D4016-1	HINGE HALF, BASE
4	1	D4016-7	STOP
5	1	D4021-1	HANDLE PLATE
6	1	D5328-1	MESH, BASE
7	1	D5328-3	MESH END, AFT
8	1	D5328-5	MESH END, FWD
9	2	D5330-1	HANDLE PLATE
10	1	D5331-101	TUBULAR BASKET BASE ASSY, LH



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163077AD

JUN 21 2017

NOTES:

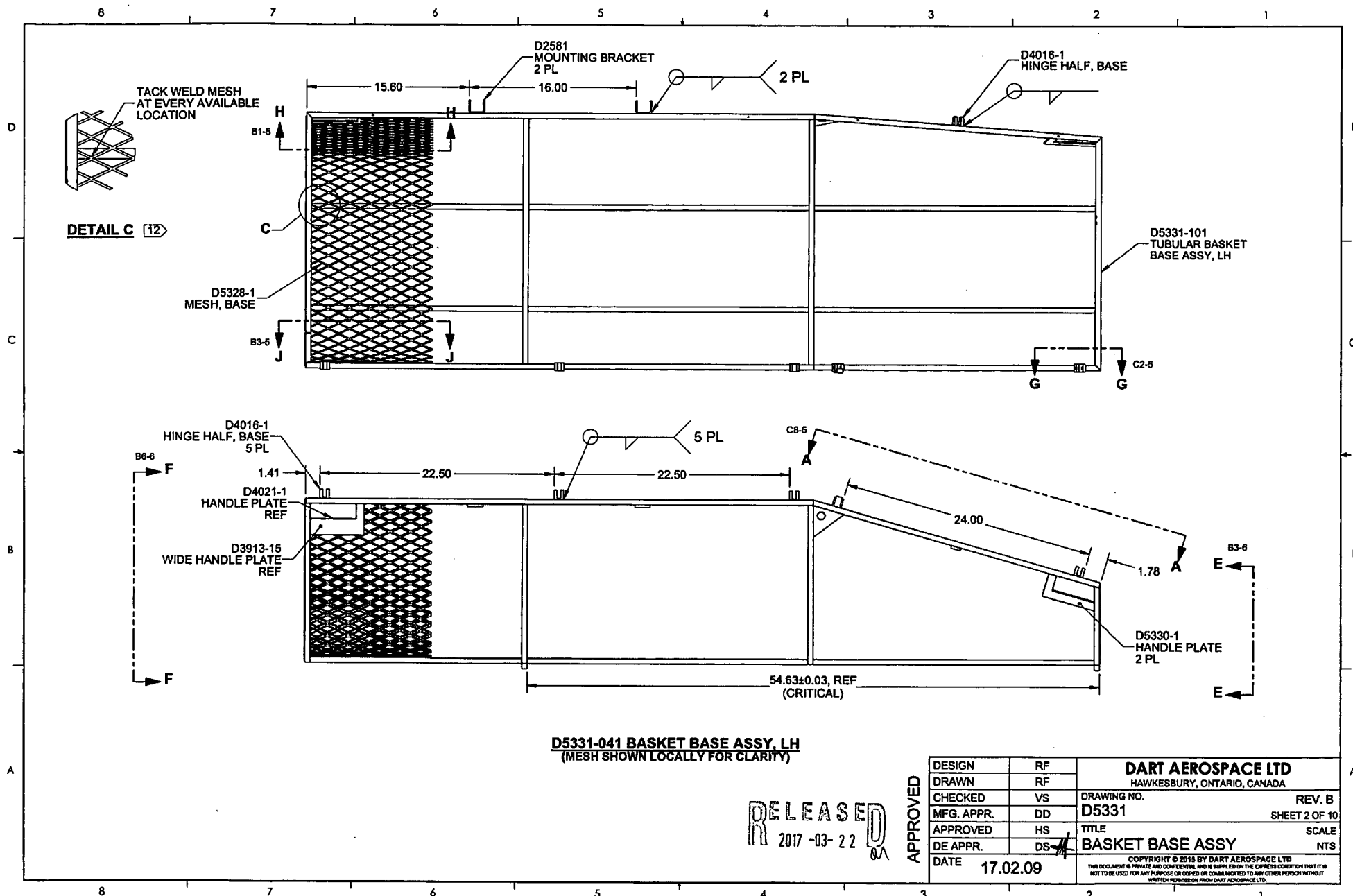
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 29.8 lbs
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5331-041
- 11) WELD PER DART QSI 004
- 12) LOCAL TRIMMING MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE

D5331-041 BASKET BASE ASSY, LH 
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2017-03-22
EN 17-535

B	REVISE -041/-042 & BOM TO ADD D4016-7 STOP (ZN A4-1, D3-1, A4-3, D3-3); ADDED DETAIL K (ZN C6-5, D4-5)		RF	17.02.09
A	NEW ISSUE		RF	15.08.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5331 TITLE BASKET BASE ASSY COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. I	
DRAWN	RF		SHEET 1 OF 10	
CHECKED	VS		SCALE	
MFG. APPR.	DD		NTS	
APPROVED	HS			
DE APPR.	DS			
DATE	17.02.09			

8 7 6 5 4 3 2 1



RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5331	SHEET 2 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
DATE	17.02.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY. -042	P/N	DESCRIPTION
	X	D5331-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	6	D4016-1	HINGE HALF, BASE
4	1	D4016-7	STOP
5	1	D4021-1	HANDLE PLATE
6	1	D5328-1	MESH, BASE
7	1	D5328-3	MESH END, AFT
8	1	D5328-5	MESH END, FWD
9	2	D5330-1	HANDLE PLATE
10	1	D5331-102	TUBULAR BASKET BASE ASSY, RH

B

D

C

B

A

D5331-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

B

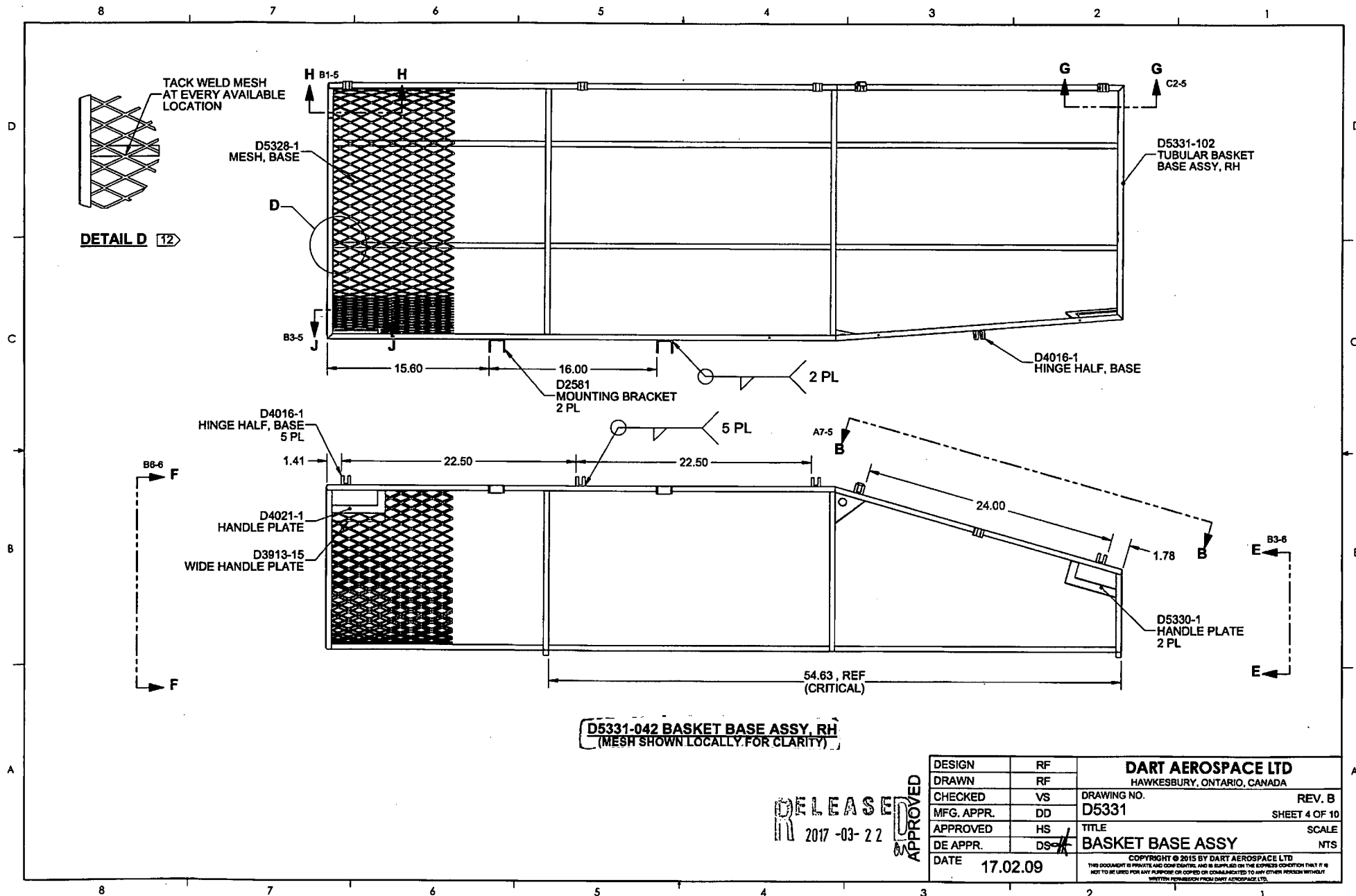
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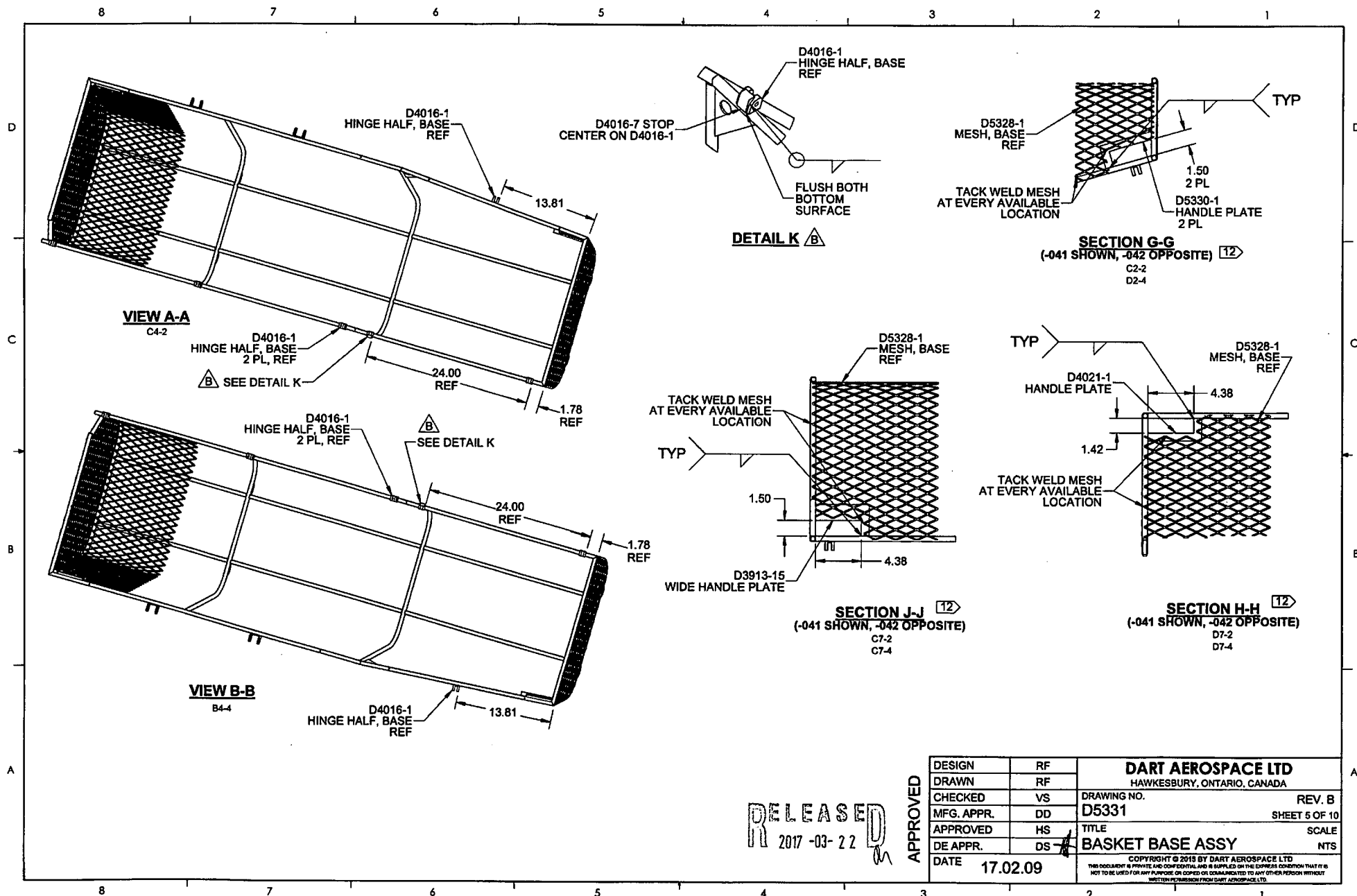
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 29.8 lbs
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5331-042
- 11) WELD PER DART QSI 004
- 12) LOCAL TRIMMING MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE

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MFG. APPR.	DD	D5331	SHEET 3 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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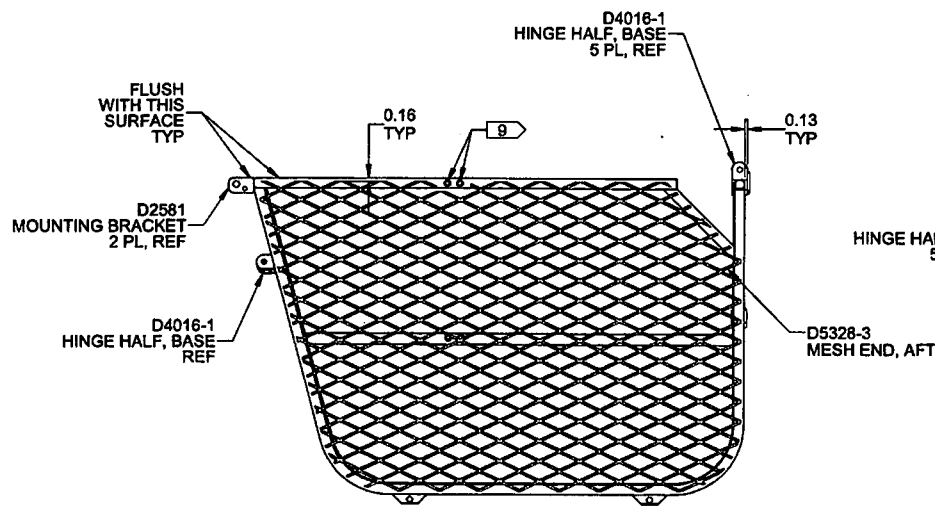




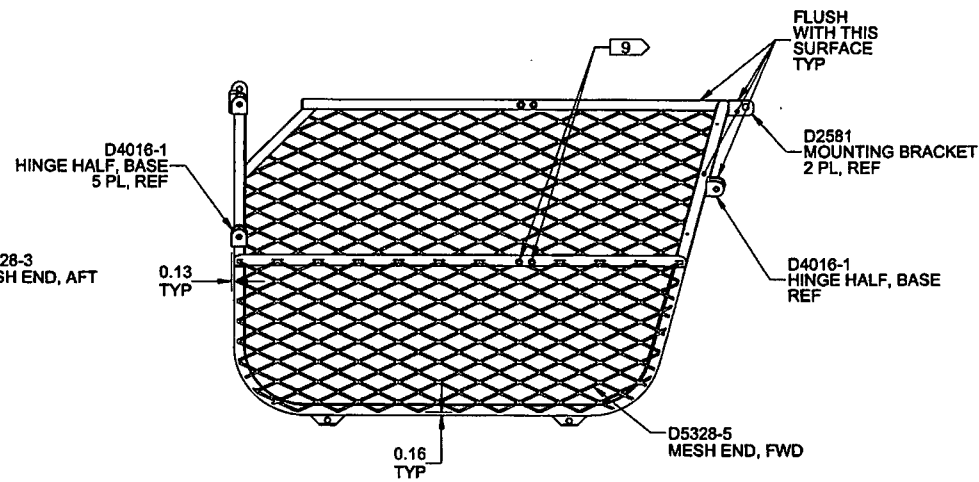
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VIEW F-F 12
 (-041 SHOWN, -042 OPPOSITE)
 B8-2
 B8-4

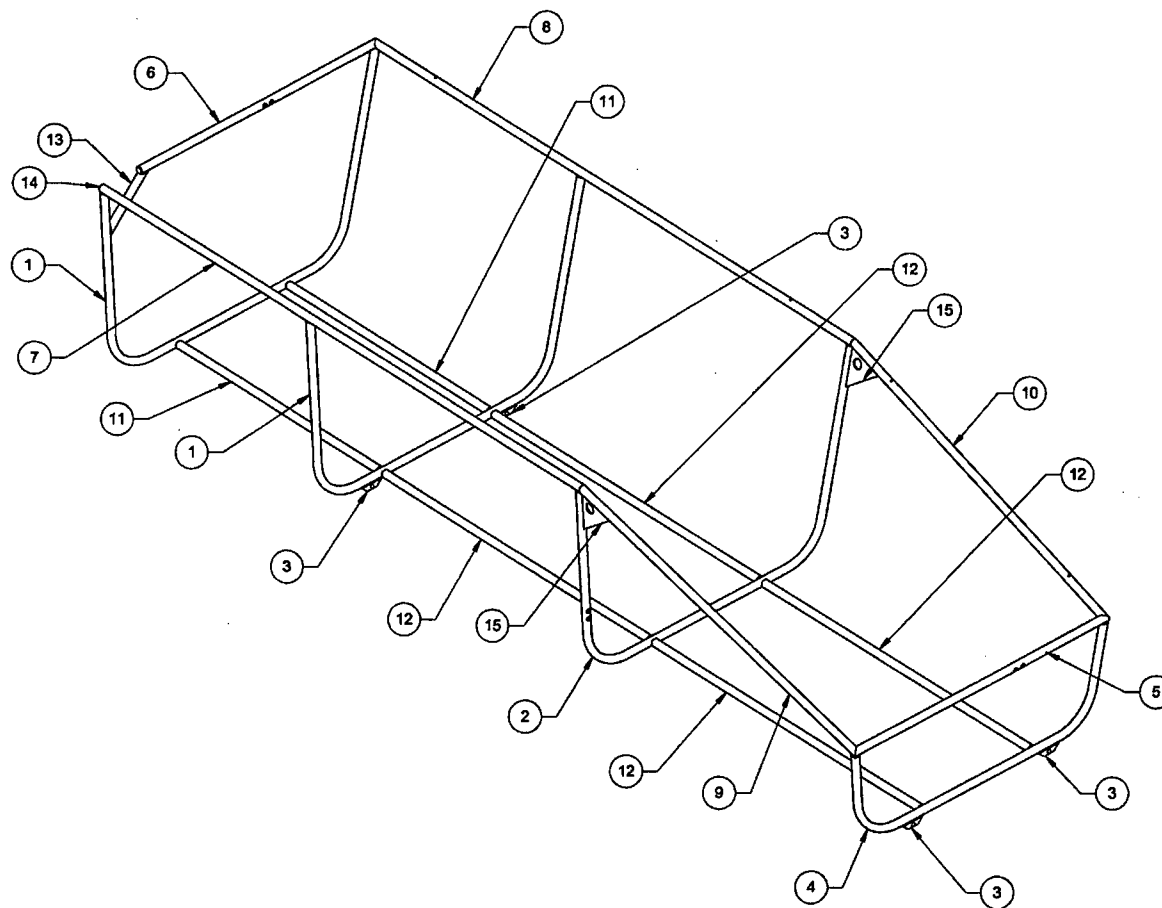


VIEW E-E 12
 (-041 SHOWN, -042 OPPOSITE)
 B1-2
 B1-4

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MFG. APPR.	DD	SHEET 6 OF 10	
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D5331-101 TUBULAR BASKET BASE ASSY, LH

NOTES:

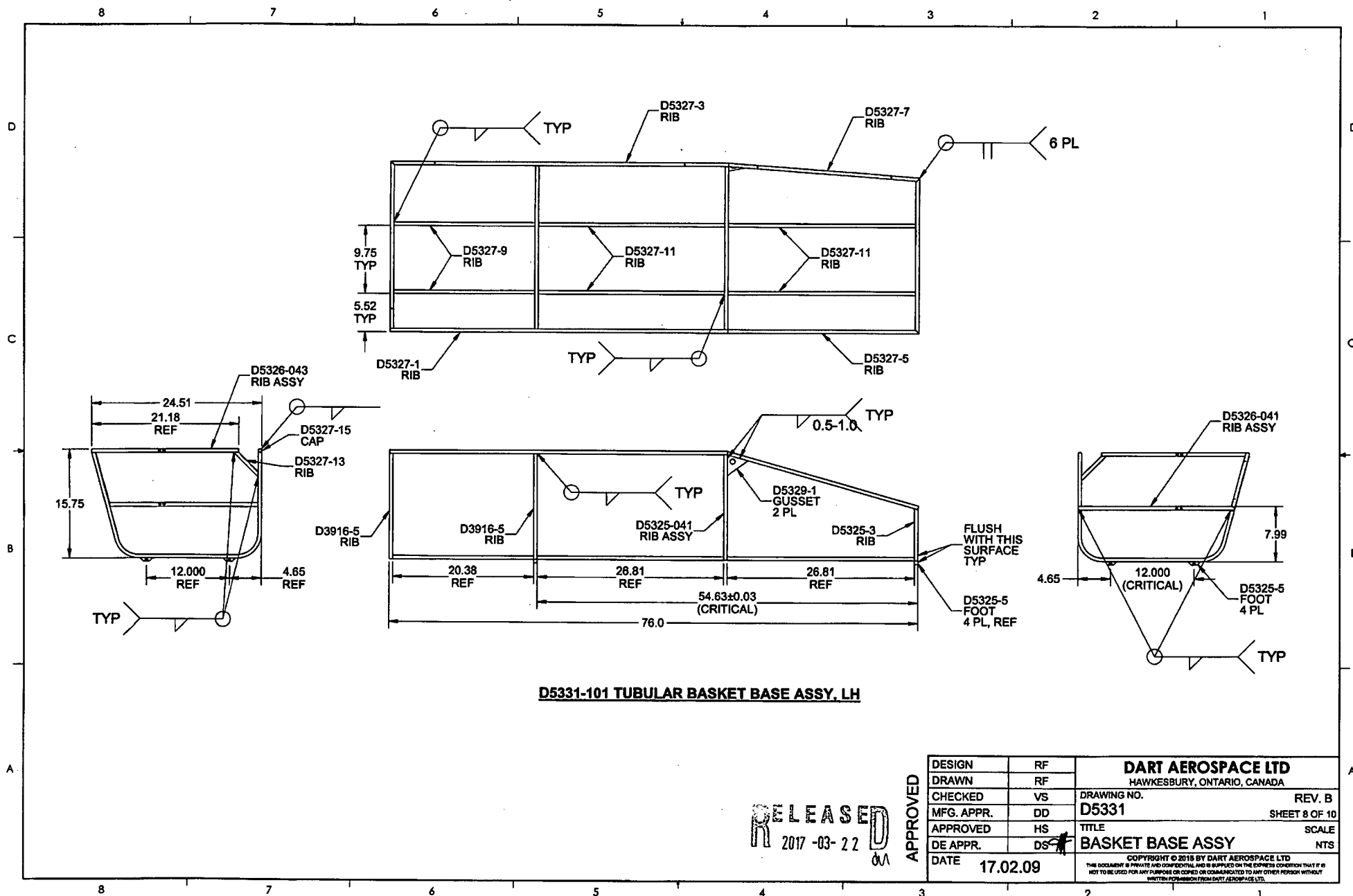
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 12.16 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5331-101
- 9) WELD PER DART QSI 004

ITEM	QTY -101	P/N	DESCRIPTION
	X	D5331-101	TUBULAR BASKET BASE ASSY, LH
1	2	D3916-5	LIGHT RIB
2	1	D5325-041	RIB ASSEMBLY
3	4	D5325-5	FOOT
4	1	D5325-3	LIGHT RIB
5	1	D5326-041	RIB ASSEMBLY
6	1	D5326-043	RIB ASSEMBLY
7	1	D5327-1	RIB
8	1	D5327-3	RIB
9	1	D5327-5	RIB
10	1	D5327-7	RIB
11	2	D5327-9	RIB
12	4	D5327-11	RIB
13	1	D5327-13	RIB
14	1	D5327-15	CAP
15	2	D5329-1	GUSSET

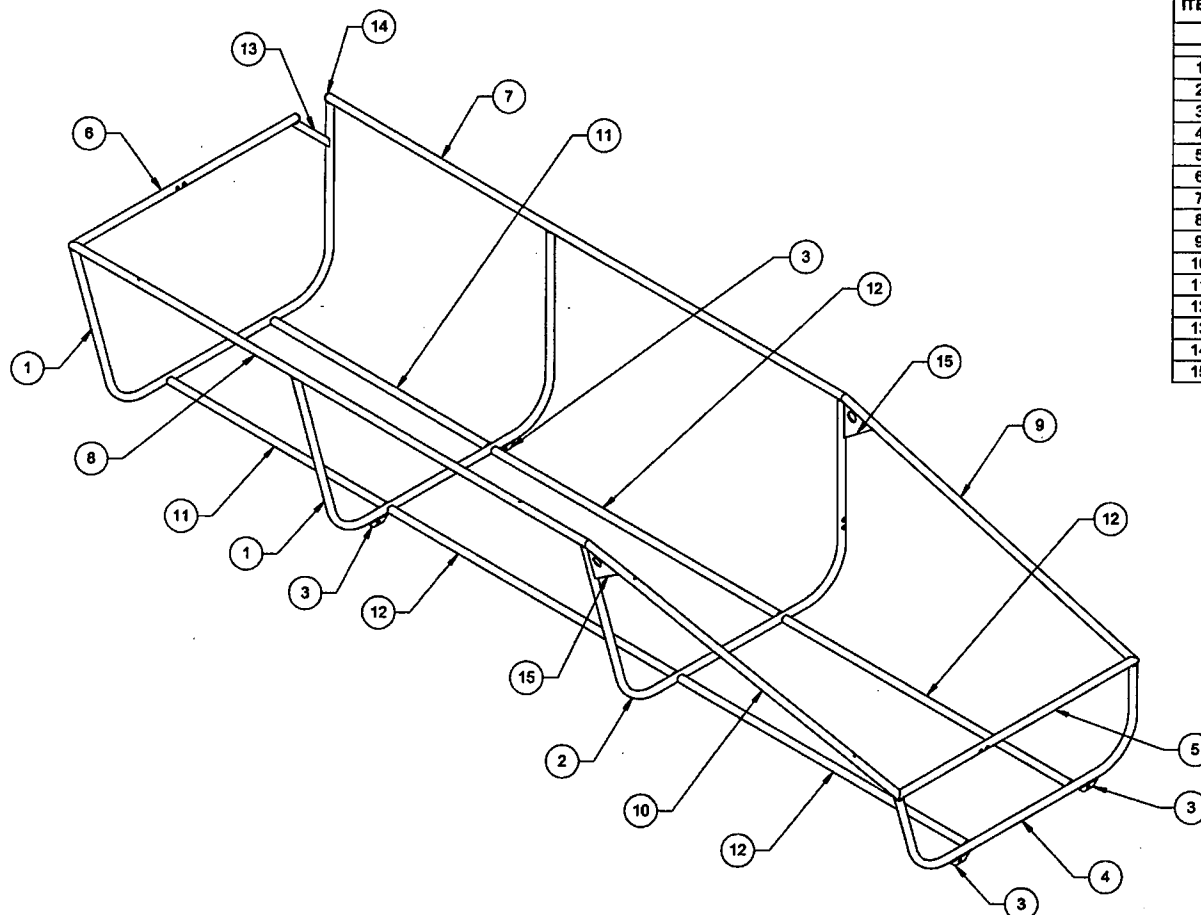
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5331	SHEET 7 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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MFG. APPR.	DD	D5331	SHEET 8 OF 10
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ITEM	QTY .102	P/N	DESCRIPTION
	X	D5331-102	TUBULAR BASKET BASE ASSY, RH
1	2	D3916-5	LIGHT RIB
2	1	D5325-041	RIB ASSEMBLY
3	4	D5325-5	FOOT
4	1	D5325-4	LIGHT RIB
5	1	D5326-041	RIB ASSEMBLY
6	1	D5326-043	RIB ASSEMBLY
7	1	D5327-1	RIB
8	1	D5327-4	RIB
9	1	D5327-6	RIB
10	1	D5327-8	RIB
11	2	D5327-9	RIB
12	4	D5327-11	RIB
13	1	D5327-13	RIB
14	1	D5327-15	CAP
15	2	D5329-1	GUSSET

D5331-102 TUBULAR BASKET BASE ASSY, RH

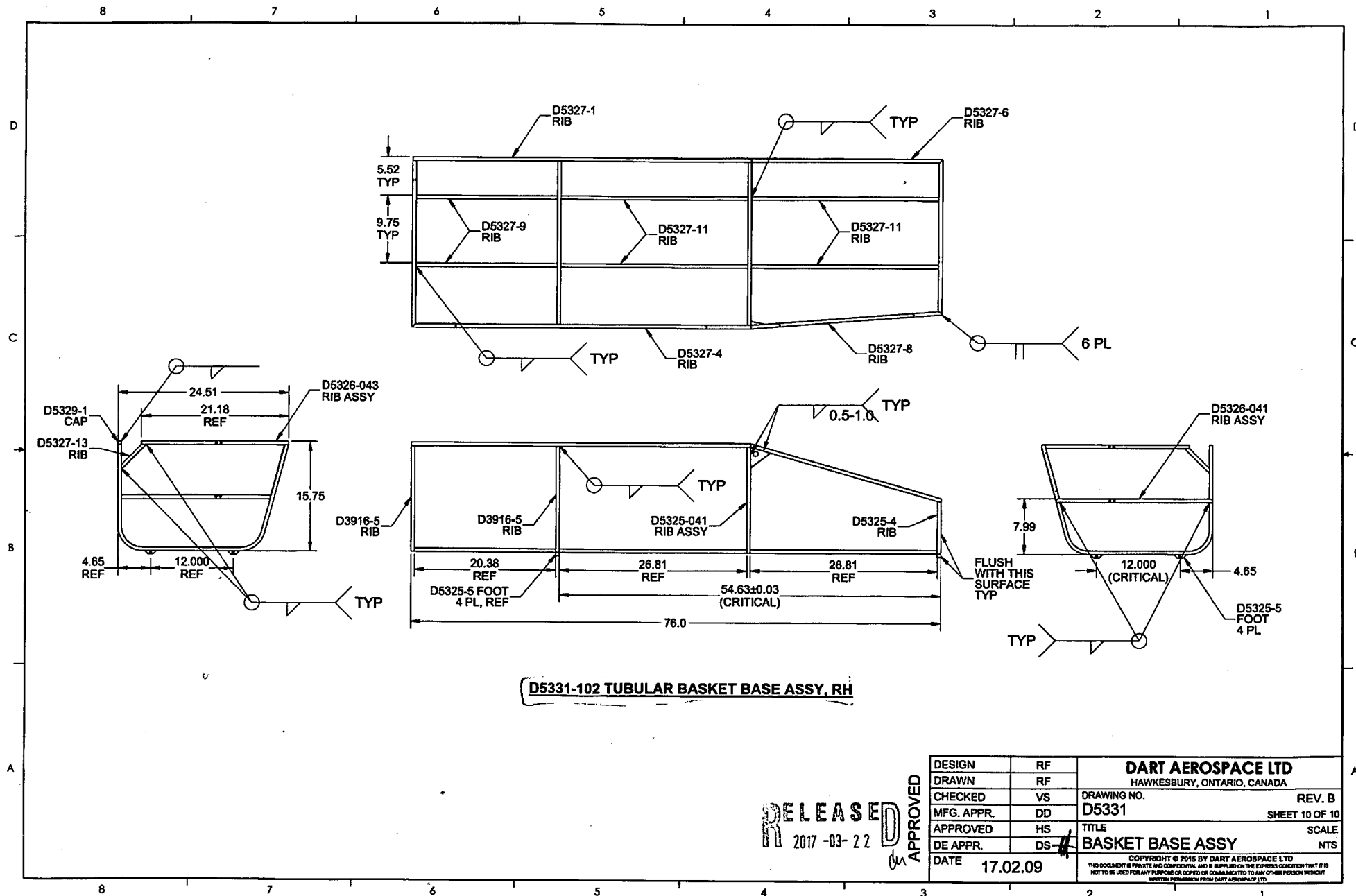
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 12.16 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5331-102
- 9) WELD PER DART QSI 004

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D5331-102 TUBULAR BASKET BASE ASSY, RH

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MFG. APPR.	DD	D5331	SHEET 10 OF 10
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